

Mark-up Specification

METHOD FOR EMPTYING AND FILLING BULK GOODS CONTAINERS AVOIDING CONTAMINATION

Background of the Invention

Field of the Invention

Method**[0001]** The present invention relates to methods for emptying and filling of bulk goods ~~containers avoiding~~from/into a container without contamination.

Description of Related Art

[0002] The steadily growing demand for industrially manufactured products is also imposing increasing demands in terms of raw materials and components that are used. The products involving an increasing degree of ~~specialisations~~specialization, which means: increasingly higher degrees of purity, increasingly more effective substances, and unfortunately, also increasingly more dangerous substances, toxicity, the triggering of allergies, and the effects of contamination and pollution are also on the increase. The problems are going in two directions. ~~Firstly~~First, in the area of operator protection - the operator must not be exposed to any danger - and secondly, in the area of product protection - the product must not be contaminated with foreign substances. These are general requirements which are imposed mainly in bio- and food technology, chemical and pharmaceutical sectors of industry.

[0003] To meet these requirements the products to be processed are not handled openly, but in closed transport containers, e.g., fixed transport containers, flexible transport containers (also called big-bags) or barrels. All transport containers may additionally be equipped with an inner film bag.

[0004] This raises the question as to how these transport containers can be emptied and filled while avoiding contamination.

~~Whilst~~**[0005]** While expensive docking systems are already available for fixed transport containers, e.g., split valves, cone systems or the like, there is absolutely no satisfactory solution for transport containers with a flexible outlet and inlet.

[0006] The problem lies in the fact that, up till now, it has not been possible to connect transport containers with a flexible outlet in a form that is sealed from the surrounding area to a

product inlet or product outlet of an installation or system, and to remove the emptied or filled barrelcontainer after emptying and filling again without contamination.

[0007] Conventional systems use mechanical clamping devices for connecting the barrelscontainers, where the outlet on the connection system is clamped and sealed. However, when the barrelcontainer is changed, both the connection system and the barrelcontainer are open. Contamination at the connection point and contamination of the operator and the surrounding area may result from dust-laden air and dripping residual product.

Summary of the Invention

[0008] The object of the invention is to provide a method for emptying and filling bulk goods containers with little contamination using protective films.

[0009] This object is achieved according to the invention with a method according to ~~Claim 1, 7, 8 and 15.~~ Advantageous embodiments of the invention constitute the object of the dependent claims as described below.

[0010] Preferred embodiments of the method according to the invention are described in the following with reference to the attached accompanying drawings, where,

Brief Description of the Drawings

[0011] Figs. 1 to 9 show method steps between an initial position and the next time this initial position is reached using a film carrier which is able to receive a film supply for several container changes, when a container with a flexible outlet is emptied,

[0012] Figs. 10 to 17 show method steps for disposal of the end of a protective film that can no longer be used and the fitting of a new one when emptying a container,

[0013] Figs. 18 to 27 show steps for individual bag emptying with a protective film for only one emptying process,

[0014] Fig. 28 shows the method during emptying a container with rigid outlet,

[0015] Figs. 29 to 39 show method steps of a filling process between an initial position and the next time this initial

position is reached, using a foil carrier which is able to receive a film supply for several container changes,

[0016] Figs. 40 to 47 show method steps for disposing of the end of a protective film that can no longer be used, and the fitting of a new one, and

[0017] Figs. 48 to 53 show method steps for cleaning the bottom of the filling/sealing mechanism.

Detailed Description of the Invention

Emptying process

[0018] As shown in Figs. 1 to 9, a connection tube 1, ~~through which a flexible transport container fitted over connection tube 1,~~ with the outlet at the bottom, through which the contents of a flexible transport container disposed over connection tube 1 are discharged, is enclosed by a hose film 3 and is sealed by tying the hose film at 3.1, at the beginning of the emptying process. The hose film extends from a film carrier 2 surrounding the connection tube 1, in which carrier the film is present in a length sufficient for several emptying processes ("endless film"). The film is guided between an axial sealing ring 5, located in a sealing ring recess 6 on the upper edge of the connection tube, and the upper edge of connection tube 1 against which it acts, and can be removed from the film carrier 2 in the required length. Hose film 3 is first tied at 3.1 above filling tube 1. Here, the hose film is pulled out of the film carrier to the extent that an end piece that can be widened into a funnel shape is produced above the tying point. This end piece is inserted in a radial expanding ring 9, which rests in a expanding ring recess 8, and is therefore clamped to the outlet edge of a flexible container (a so-called big bag, for example) arranged above filling tube 1, by means of a counter ring 10 designed as a disposable part, whose outside diameter is roughly equal to the inside diameter of radial expanding ring 9, at which time the container to be emptied, as shown at 11.1, is still tied up (See Figs. 1 to 3).

[0019] The hose film is then ~~tied~~untied at 3.1, which gives rise to the condition shown in Fig. 4. The container to be emptied is then opened at 11.1 and the bulk goods contained in the container drop from the container through connection tube 1 (Fig. 5).

[0020] A pocket 3.8 of the hose film is ~~here placed~~placed inside connection tube 1 and protects the upper region of connection tube 1 from the adhesion of product. If the product pressure is high, protective film 3 can be retained by a support tube 7 (shown in Fig. 5 as a dotted line). As soon as the flexible container (big bag) is emptied, and evacuated if necessary, the free end of hose film 3 is pulled together over expanding ring recess 8 and connected to the outlet of the container 11 at 3.2. In particular, it is tied to it as shown (Fig. 6).

[0021] Axial sealing ring 5 is then relieved of load and hose film 3 is pulled out until sufficient clean hose film is obtained that it can be sealed in the clean region at 3.4, and immediately above it ~~at in region~~in region 3.3 (see, Fig. 6). In particular it is tied, as shown.

[0022] Radial expansion ring 9 is then relieved of load and the hose film separated between the tying points 3.3 and 3.4 (see, Fig. 7). Flexible container 11 can now be disposed of free of contamination. Counter ring 10 is a disposable part which is also disposed of.

[0023] ~~Hose film~~Hose film 3 is then pulled out of film carrier 2 again, until sufficient film is present below tying point 3.4 for a new connection funnel and it can be tied again immediately above the filling tube at 3.1 (Fig. 8). With the removal of the upper tying at ~~3.4~~3.4, the hose film can be expanded to form a funnel with which the condition shown in Fig. 1 is again reached and the device is ready for a new filling process.

[0024] This means that after the emptied container is detached from connection tube 4, both the contaminated outlet of the container and the contaminated connection tube are never open but are always sealed by surrounding protective film.

[0025] Figs. 10 to 17 show method steps from a time when the remaining film contained in film carrier 2 is no longer sufficient for a further emptying process. The remaining film must be removed and at the same time it must be ensured that neither the remaining film can fall into connection tube 1 nor the connection tube, possibly contaminated, is unsealed at the top.

[0026] Fig. 10 shows the condition according to Fig. 7, except that the hose film supply is at the end.

[0027] As shown in Fig. 11, axial sealing ring 5, which clamps the hose film against the filling tube edge, is relieved of load and both recess 6 for axial sealing ring 5 and recess 8 for the expansion ring are removed so that film carrier 2 is accessible and can be removed (Fig. 11), a new film carrier 2, with a new film, is fitted (Fig. 12) and the end of the hose film of the new film carrier 2 is secured to a suitable elastic fixing ring 4 on connection tube 1. The beginning of the new hose film is then pulled over the old remaining film and both films are tied at 3.5 underneath tying point 3.4 (Fig. 13). Both films are then pulled up ~~enew~~with the old film inside the ~~ether~~new film together with the elastic fixing ring of the old film, and the new hose film tied twice ~~at 3.6 and 3.7~~ underneath the old hose film lying in it ~~at 3.6 and 3.7~~ (Fig. 14). The new hose film is then cut between the two tying points 3.6 and 3.7 so that the remaining old hose film, packed in a piece of new hose film, can be disposed of (Fig. 15). The ~~ting~~tying point at 3.7 prevents the packet cut off with the old hose film from falling into connection tube 1, and at the same time ensures that the connection tube is sealed.

[0028] Figs. 16 ~~and~~& 17 correspond to Figs. 8 ~~and~~& 9 and the associated method steps correspond to those described with reference to Figs. 8 ~~and~~& 9.

[0029] During the emptying of an individual bag, it is not necessary to provide hose film for several emptying processes. Connection tube 1 is then surrounded with hose film for a single emptying process, the design of the parts being otherwise the same.

[0030] The method steps for this case, including disposal of the used hose film ~~used~~ by means of a new hose film, are shown in Figs. 18 to 27. In this case Figs. 18 to 21 correspond to Figs. 2 to 5, Figs. 22 and 23 correspond to Figs. 6 and 7, Figs. 24 and 25 correspond to Figs. 12 and 13, and Figs. 26 and 27 correspond to Figs. 14 to 17, the only difference being that the packet containing the old film is not cut off until the end of the process.

[0031] The advantage of this embodiment is that the connection funnel is not contacted by product and is therefore completely free of contamination, thus the connection to the outlet of the container to be emptied takes place without contamination. This is because a new single film, screened by the old hose

film, does not come into contact with the edge of the connection tube, which can be contaminated under certain circumstances. The new hose film is protected in the same way as the beginning of an endless film, which replaces a used endless film.

[0032] Fig. 28 shows the method when applied to a container with a rigid outlet, the container being designed as a fixed transport container 14 with a sealing cap 13 in the container.

[0033] Radial expansion ring 9, with expanding ring recess 8 and counter ring 10, are dispensed with. The connection funnel of hose film 3, described above, is secured directly to the container outlet by means of a clamp band 12. After the tie is loosened at tying point 3.1, the container can be emptied.

[0034] After emptying, hose film is tied twice in the clean region, after being pulled out, as described with reference to Fig. 6, and cut in between ~~(as in Fig. 7)~~ 7. This ensures that the container can be cut off without contamination.

[0035] As far as the replacement of film carrier 2 is concerned, this is carried out exactly as described above for containers with a flexible outlet.

[0036] Apart from sealing point 3.1, the other sealing points 3.2 - 3.7 can also be advantageously formed, for example, by welding or another permanent type of sealing.

Filling process

[0037] As shown in Figs. 29 and 39, at the beginning of the filling process, a connection tube 1, through which a flexible transport container placed underneath it is to be filled, is wrapped in a hose film 3 and sealed by tying of the hose film at 8.1. To protect from falling product and to ~~minimise~~ minimize product loss, a further sealing mechanism 20 can be integrated in connection tube 1. Hose film 3 extends from a film carrier 2 surrounding the connection tube, in which carrier it is present in a length sufficient for several filling processes ("endless film"). Film 3 is guided between a radial sealing ring 19 located at the lower edge of the connection tube and connection tube 1, and can be taken from film carrier 2 in the required length by pulling. ~~Hose~~ The hose film 3 is first tied at 8.1 underneath connection tube 1. Here, the hose film is pulled out of the film carrier until a piece of hose that can be

widened is produced underneath the tie. Counter ring 10 is inserted in this end piece. Inlet 11.2 of the flexible transport container 11 can then be clamped and sealed with protective film 3 and counter ring 10 in the container inlet radial sealing ring 9 (see, Figs. 29 to 31).

[0038] The connection between connection tube 1 and transport container inlet 11.2 is opened by opening the tie of the hose film at 8.1. The transport container can be filled after sealing mechanism 20 is opened (Fig. 33). Here, a pocket of the hose film₃ is placed on the edge of the container inlet_{11.2} and protects it from coarse product adhesion.

[0039] As soon as the flexible container (big bag) 11 is completely filled and sealing mechanism 20 is closed, radial sealing ring 9 on connection tube 1 is relieved of load and fresh hose film 3 is pulled out until sufficient clean hose film is obtained for it to be sealed in the clean region at 8.2 and immediately underneath at 8.3 (see Fig. 34). In particular, it can be tied at those points, as shown.

[0040] After hose film 3 is cut off between seals 8.2 and 8.3, a product sample can be removed by hand, if necessary, from transport container 11 and enclosed in the hose film by tying at 8.4. Inlet 11.2 of transport container 11 must then be tied initially above radial sealing ring 9 with tie 8.5, then below radial sealing ring 8.6, and once again, immediately below this, at 8.7. Radial sealing ring 9 is then relieved of load and the hose film is cut off between tying points 8.4 and 8.5 (cutting off the sample bag) and between 8.6 and 8.7 (see, Fig. 37). The film pocket, with counter ring 10 enclosed, can now be disposed off without contamination.

[0041] Hose film is then pulled out of film carrier 2 once again until sufficient film is present above tying point 8.2 for a new connection funnel, and this can be tied once again immediately underneath connection tube 1 at 8.1 (Fig. 38). When the lower tie at 8.2 is removed, hose film 3 can again be widened to form a funnel, with which the condition shown in Fig. 29 is again reached and the device is ready for a new filling process.

[0042] This means that after the filled container 11 is detached from connection tube 1 both the contaminated inlet of the container and the contaminated connection tube are never open but are always sealed by surrounding protective film.

[0043] Figs. 40 to 47 show method steps from a time when the remaining film contained in film carrier 1 is no longer sufficient for a further filling process. The remaining film must be disposed of and at the same time it must be ensured that the filling tube is at no time unsealed.

[0044] Fig. 40 shows the condition shown in Fig. 37, except that the hose film supply is used up.

[0045] As shown in Fig. 41, radial sealing ring 19 and container inlet radial sealing ring 9 are removed so that film carrier 2 is accessible and can be removed. A new film carrier 2 with new film 3 is fitted (Fig. 42) and the end of the hose film is secured with a suitable elastic fixing ring 4 to connection tube 1. The beginning of the new hose film is then pulled over the old remaining film and sealed at 8.8 (Fig. 43). The old film with its fixing ring is then pulled off and enclosed in a film pocket by tying the new film 8.9 and the hose film is tied once again at a short distance above 8.9 at 8.10 (Fig. 44). After hose film 3 is cut between tying points 8.9 and 8.10, the remaining old film can be disposed of with the new protective film surrounding it. Radial sealing 19 and container inlet radial sealing ring 9 can now be returned to the working position.

[0046] Figs. 46 and 47 correspond to Figs. 38 and 39 and the associated method steps for forming a new connection funnel correspond to those described with reference to Figs. 38 and 39.

[0047] Figs. 48 to 51 show method steps that are required if it is necessary to clean the bottom of sealing mechanism 20 due to product adhesions.

[0048] Fig. 48 shows the condition shown in Fig. 39 after completion of a filling process. A cleaning cloth is packed in a film bag in a suitable clean surrounding area, with or without cleaning agent. This bag can now be enclosed in the connection funnel of hose film 3, with tie 8.12. After tie 8.1 is loosened and the cleaning bag is opened, the surface of sealing mechanism 20 can be wiped. Protective film 3 is then tied again at 8.2 and 8.13 briefly underneath connection tube. The hose film is cut off between the tying points and the film pocket is disposed off with the cleaning utensils (Figs. 50 and 51).

[0049] Figs. 52 and 53 correspond to Figs. 38 and 39, and the associated method steps for forming a new connection funnel correspond to those described with reference to Figs. 38 and 39.

[0050] Apart from sealing point 8.1, the other sealing points 8.2 - 8.13 can advantageously also be formed by welding, for example, or another permanent method of sealing.

Reference symbols:

- 1 ~~Connection tube~~
 - 1.1 ~~Bead for protective film (endless film end)~~
 - 1.2 ~~Bead for protective film (film change)~~
- 2 ~~Film carrier~~
- 3 ~~Hose film~~
 - 3.1—3.7 ~~Tying and sealing points~~
 - 3.8 ~~Film pocket~~
 - 8.1—8.12 ~~Tying and sealing points~~
- 4 ~~Elastic fixing ring~~
- 5 ~~Axial sealing ring (static or dynamic)~~
- 6 ~~Sealing ring recess~~
- 7 ~~Support tube~~
- 8 ~~Expansion ring recess~~
- 9 ~~Radial expansion ring (radial sealing ring)~~
- 10 ~~Counter ring (disposable)~~
- 11 ~~Flexible transport container (e.g. big bag)~~
 - 11.1 ~~Sealing point on the transport container~~
 - 11.2 ~~Transport container inlet~~
- 12 ~~Clamp band~~
- 13 ~~Sealing cap (drip protection)~~
- 14 ~~Fixed transport container (container)~~
- 31 ~~Dosing mechanism, conveying mechanism, installation~~
- 33 ~~Flexible balance disconnection~~
- 44 ~~Aeration and de-aeration~~
- 54 ~~Cleaning cloth for sealing mechanism~~
- 55 ~~Fixing for film carrier~~

CLAIMS

- 1- ~~A method for emptying bulk goods, without contamination, from a container with a flexible outlet into a device mounted after it, via a connection tube (1), wherein the method has the following method steps:~~
~~arrangement of the container with an outlet tied to a tying point (11.1) above the connection tube,~~
~~arrangement of a hose film (3) around the connection tube, so that it rests against the edge of the connection tube on the inlet side so that it seals,~~
~~tying the hose film above the connection tube so that one end of the hose film, which can be widened in the shape of a funnel, remains above the tying point (3.1),~~
~~clamping connection of the outlet of the flexible container and the hose film so that free hose film remains over the clamp connection,~~
~~detachment of the tying points (11.1, 3.1) from the outlet and hose film and emptying of the bulk goods,~~
~~tying (3.2) of the free end of the hose film remaining above the clamping point to the container outlet and its securing to it,~~
~~pulling hose film out of a hose film supply until clean hose film (3) is available above the connection tube (1),~~
~~sealing of the hose film at two adjacent sealing points (3.3, 3.4) in the clean region,~~
~~cutting of the hose film between the two sealing point (3.3, 3.4),~~
~~pulling of hose film out of the hose film supply and tying the same again at a tying point (3.1) at a distance from the cutting point,~~
~~removing the sealing point (3.4) in the region of the cutting point and widening of the hose film between the cutting point and the tying point (3.1) located at a distance from the cutting point to form a funnel shape.~~
- 2- ~~The method according to Claim 1, characterised in that an axial sealing ring (5), acting against the edge of the~~

~~connection tube on the inlet side above the hose film, is used to make the sealing contact of the hose film against the edge of the connection tube (1) on the inlet side.~~

- ~~3. The method according to any one of the preceding claims, characterised in that a film carrier (2) surrounding the connection tube (1) is used to receive the hose film supply.~~
- ~~4. The method according to Claim 3, characterised in that the end of the hose film is revealed and is clamped with an elastic fixing ring (4) against a first bead (1.1) running around the periphery of the connection tube (1).~~
- ~~5. The method according to any one of the preceding claims, characterised in that a radial expansion ring (9) surrounding the connection point on the outside and a counter ring (10) supporting the connection point on the inside are used for the clamping connection of the outlet of the flexible container and the hose film.~~
- ~~6. The method according to Claim 4, wherein, when the hose film supply~~What is used up, the hose film~~claimed is no longer pulled out of the hose film supply and the following method steps are carried out after the hose film has been cut between the two sealing points (3.3, 3.4):~~
 - ~~removing the axial sealing ring (5),~~
 - ~~pulling the elastic fixing ring (4), with the hose film, out of the first bead (1.1) into a second bead (1.2) located above the first bead (1.1),~~
 - ~~fitting a new film carrier (2) with new hose film, and clamping the end of the new hose film with an elastic fixing ring (4) in the first bead (1.1) against the connection tube (1),~~
 - ~~pulling the beginning of the new hose film out of the film carrier (2),~~

~~sealing the new hose film against the old hose film at a
sealing point (3.5) located underneath the sealing point
(3.4) of the old hose film ,
pulling up the new hose film with the old hose film
connected to it until the end of the old hose film is
released from the second bead (1-2) ,
sealing the new hose film underneath the end of the old
hose film at two adjacent sealing points (3.6 ,3-7) ,
cutting the new hose film between the two sealing points
(3.6, 3) , disposing of the old hose film packed in the
new hose film ,
further pulling up of the new hose film and tying the new
hose film at a tying point (3.1) located at a distance
from the sealing point (3.7) remaining at the end ,
removing the end sealing point (3.7) and widening of the
new hose film to form a funnel shape.~~

Abstract

7. ~~A method for emptying bulk goods, without contamination, from a container with a flexible outlet into an after-mounted device via a connection tube (1), wherein the method has the following method steps:~~
~~arrangement of the container with an outlet tied to a tying point (11.1) above the connection tube,~~
~~arrangement of a hose film (3) sufficient for one refilling process around the connection tube, so that it rests against the edge of the connection tube on the inlet side so that it seals,~~
~~tying the hose film above the connection tube so that one end of the hose film, which can be widened in the shape of a funnel, remains above the tying point (3.1),~~
~~clamping connection of the outlet of the flexible container and the hose film so that free hose film remains over the clamp connection,~~
~~detachment of the tying points (11.1, 3.1) from the outlet and hose film and emptying of the bulk goods,~~
~~tying (3.2) of the free end of the hose film remaining above the clamping point to the container outlet and its securing to it,~~
~~pulling the hose film until clean hose film (3) is available above the connection tube (1),~~
~~sealing of the hose film at two adjacent sealing points (3.3, 3.4) in the clean region,~~
~~cutting of the hose film between the two sealing point (3.3, 3.4),~~
~~fitting a new hose film and clamping the end of the new hose film against the connection tube underneath the old hose film,~~
~~pulling out the beginning of the new hose film,~~
~~sealing the new hose film against the old hose film at a sealing point (3.5) located underneath the sealing point (3.4) of the old hose film,~~

~~pulling up the new hose film with the old hose film connected to it until the end of the old hose film is released,~~

~~sealing the new hose film underneath the end of the old hose film at a sealing point (3.6),~~

~~cutting the new hose film underneath the sealing point (3.6), disposing of the old hose film packed in the new hose film,~~

~~further pulling up of the new hose film and tying the hose film at a tying point (3.1) located at a distance from the sealing point (3.6) remaining at the end, widening the new hose film to form a funnel.~~

8. ~~The method for emptying bulk goods, without contamination, from a transport container with a rigid outlet into an after-mounted device via a connection tube (1), wherein the method has the following method steps:~~
- ~~arranging the transport container in the sealed condition above the connection tube,~~
- ~~arranging a hose film (3) around the connection tube, so that it rests against the edge of the connection tube on the inlet side so that it seals,~~
- ~~tying the hose film above the connection tube so that one end of the hose film, which can be widened in the shape of a funnel, remains above the tying point (3.1),~~
- ~~clamping connection of the rigid outlet of the container and the beginning of the hose film,~~
- ~~detachment of the tying point (3.1) of the hose film and emptying of the bulk goods,~~
- ~~pulling hose film out of a hose film supply until clean hose film (3) is available above the connection tube (1),~~
- ~~sealing of the hose film at two adjacent sealing points (3.3, 3.4) in the clean region,~~
- ~~cutting of the hose film between the two sealing point (3.3-3.4).~~

~~pulling of hose film out of the hose film supply and tying the same again at a tying point (3.1) at a distance from the cutting point, removing the tying point (3.4) in the region of the cutting point and widening of the hose film between the cutting point and the tying point (3.1) located at a distance from the cutting point to form a funnel shape.~~

- ~~9. The method according to Claim 8, characterised in that an axial sealing ring (5) acting over the hose film against the edge of the connection tube on the inlet side is used for making the sealing contact of the hose film against the edge of the connection tube (1) on the inlet side.~~
- ~~10. The method according to any one of Claims 8 and 9, characterised in that a film carrier (2) surrounding the connection tube (1) is used to receive the hose film supply.~~
- ~~11. The method according to Claim 10, characterised in that the end of the hose film is revealed and is clamped with an elastic fixing ring (4) against a first bead (1.1) running round the periphery of the connection tube (1).~~
- ~~12. The method according to Claim 11, wherein when the hose film supply is used up, the hose film is no longer pulled out of the hose film supply and the following method steps are carried out after the hose film has been cut between the two sealing points (3.3, 3.4):
removing the axial sealing ring (5),
pulling the elastic fixing ring (4) with the hose film out of the first bead (1.1) into a second bead (1.2) located above the first bead (1.1),
fitting a new film carrier (2) with new hose film, and
clamping the end of the new hose film with an elastic fixing ring (4) in the first bead (1.1) against the connection tube (1).~~

~~pulling the beginning of the new hose film out of the film carrier (2),~~
~~sealing the new hose film against the old hose film at a sealing point (3.5) located underneath the sealing point (3.4) of the old hose film,~~
~~pulling up the new hose film with the old hose film connected to it until the end of the old hose film is released from the second bead (1.2),~~
~~sealing the new hose film underneath the end of the old hose film at two adjacent sealing points (3.6, 3.7),~~
~~cutting the new hose film between the two sealing points (3.6, 3.7), disposing of the old hose film packed in the new hose film,~~
~~further pulling up of the new hose film and tying the new hose film at a tying point (3.1) located at a distance from the sealing point (3.7) remaining at the end,~~
~~removing the end sealing point (3.7) and widening of the new hose film to form a funnel shape.~~

- ~~13. The method according to any one of the preceding claims, characterised in that the sealing points (3.2-3.7) are designed as tying points.~~
- ~~14. The method according to any one of Claims 1-12, characterised in that the sealing points (3.2-3.7) are designed as welds.~~
- ~~15. A method for filling bulk goods, without contamination, into a container with a flexible inlet from a pre-mounted device via a connection tube (1), wherein the method has the following method steps:
arranging the container with open inlet above the connection tube,
arranging a hose film (3) around the connection tube so that it rests sealing against the edge of the connection tube on the inlet side,~~

~~tying the hose film underneath the connection tube so that one end of the hose film that can be widened to form a funnel shape remains underneath the tying point (8.1), clamping connection of the inlet of the flexible container and the hose film so that a free end of the inlet remains above the clamped connection, detachment of the tying point (8.1) of the hose film and filling the container with bulk goods, pulling hose film out of a hose film supply until clean hose film (3) is available underneath the connection tube (1), sealing the hose film at two adjacent sealing points (8.2, 8.3) in the clean region, cutting the hose film between the two sealing points (8.2, 8.3), tying (8.5) the free end of the inlet remaining above the clamping point against the hose film and securing it to it, sealing of the inlet underneath the clamped connection at two adjacent points (8.6, 8.7), and cutting the inlet between them, pulling hose film out of the hose film supply and retying the same at a tying point (8.1) at a distance from the cutting point of the hose film, removing the sealing point (8.2) in the region of the cutting point of the hose film, and widening the hose film between the cutting point and the tying point (8.1) located at a distance from the cutting point to form a funnel shape.~~

16. The method according to Claim 15, characterised in that a radial sealing ring (19) acting overfor the hose contamination-preventing transferring bulk material between a container having a flexible opening and a connecting tube using a tubular film against is placed around the connecting tube; the tubular film is tied beyond the connecting tube leaving a free end of the connection tube on tubular film beyond the outlet side is used to make tying point; the sealing contact flexible opening and the tubular film are connected; the tying points of the hose film against outlet and the tubular film

are untied, and the bulk material transferred; the free end of the connection tube (1) on tubular film, is constricted and additional tubular film is pulled from a tubular film supply until clean tubular film is available beyond the outlet side connecting tube; the tubular film is closed at two points in the clean section and cut in two between them; additional tubular film is pulled from the tubular film supply, and tied at a tying point located at a distance from the cutting point.

- ~~17. The method according to Claim 15 or 16, characterised in that a film carrier (2) surrounding the connection tube (1) is used to receive the hose film supply.~~
- ~~18. The method according to Claim 17, characterised in that the end of the hose film is revealed and clamped with an elastic fixing ring (4) against a first bead (1.1) running round the periphery of the connection tube (1).~~
- ~~19. The method according to any one of Claims 15 — 18, characterised in that a radial expanding ring (9) surrounding the connecting point on the outside and a counter ring (10) supporting the connecting point on the inside are used for the clamping connection of the inlet of the flexible container and the hose film.~~
- ~~20. The method according to Claim 18, wherein, when the hose film supply is used up, the hose film is no longer pulled out of the hose film supply after the hose film is cut between the two sealing points (8.2, 8.3), and the following method steps are carried out:
removing the axial sealing ring (19),
pulling the elastic fixing ring (4), with the hose film, out of the first bead (1.1) into a second bead (1.2) located underneath the first bead (1.1),
fitting a new film carrier (2) with new hose film, and clamping the end of the new hose film with an elastic fixing ring (4) in the first bead (1.1) against the connection tube (1),
pulling the beginning of the new hose film out of the film carrier (2),~~

~~sealing the new hose film at a sealing point (8.8)
located underneath the sealing point (8.1) of the old
hose film,
pulling down the new hose film with the old hose film
until the end of the old hose film is released from the
second bead (1.2),
sealing the new hose film above the end of the old hose
film at two adjacent sealing points (8.9, 8.10),
cutting the new hose film between the two sealing points
(8.9, 8.10), disposing of the old hose film packed in the
new hose film,
further pulling down of the new hose film and tying the
new hose film at a tying point (8.1) located at a
distance from the sealing point (8.10) remaining at the
end,
removing the end sealing point (8.10) and widening of the
new hose film to form a funnel shape.~~